

AI 1.00

Work Order ID 85914

85914

June-18-12 2:30:59 PM

Item ID: D3765-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Clevis

Stop ***NS2***

Start Date: 18/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/18

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3765	Rev A								
100	DOOSAN LATHE	0.00							
100									
Doosan	Memo	0.00							
Doosan Lathe	1- Turn as per Folio FA744 Rev: _____ & Dwg D3765 Rev: _____ 2-Deburr per dwg D3765								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

12

SL 120116

12

SL 120116

12

SL 120117

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

June-18-12 2:30:59 PM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

10

10

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

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June-18-12 2:30:59 PM

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Page 3

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Item Name: Clevis

Stop ***NS2***

Start Date: 18/06/2012 Start Qty: 10.00

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Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 10.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/19/12

mk
12-09-12

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

June-18-12 2:31:03 PM

Page 1

Work Order ID: 85914

85914

Parent Item: D3765-1

D3765-1

Parent Item Name: Clevis

Start Date: 18/06/2012

Required Date: 02/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 08-05-05 JLM Verified By:EC
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.000		Purchased	No			100	f	66.4230	0.1875	1.973684			

M6061T6R1 000

**

ROUND BAR 1.00"

Location	Loc Qty	Loc Code
013	22.42	
121192	22.42	
MAT008	24	
121070	24	
MAT013	20.003	
116406	14.303	
118271	5.7	

224 SL 12/5/16

W/O:		WORK ORDER CHANGES					
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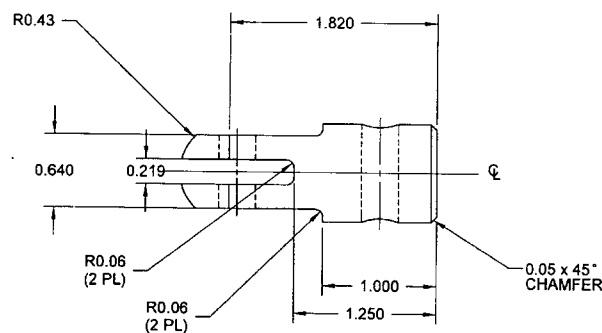
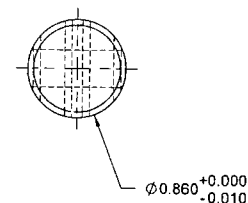
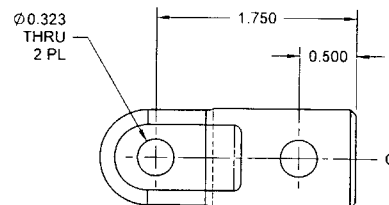
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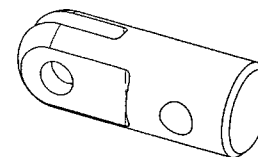
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D3765-1 CLEVIS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 85914 MLW
12/06/10

RELEASED
08-06-16

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

REV.	NEW ISSUE	DESCRIPTION	HS	08.06.04
DESIGN	HS		BY	DATE
DRAWN	HS			
CHECKED		DART AEROSPACE LTD		REV. A
MFG. APPR.		HAWKESBURY, ONTARIO, CANADA		SHEET 1 OF 1
APPROVED		D3765		SCALE
DE APPR.		CLEVIS		NTS
DATE	08.06.04			

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